

Work Order ID 52809

October 14, 2009 11:48:29 AM



Page 1

| | | | | | | |
|----------------|-----------------------|------------|-------|-------|---------------|--|
| Item ID: | D3953-5 | Accept | | Setup | Start | |
| Revision ID: | A | | | | Stop | |
| Item Name: | Gas Spring Stud, Base | | | | | |
| Start Date: | 14/10/2009 | Start Qty: | 20.00 | | Cust Item ID: | |
| Required Date: | 30/10/2009 | Req'd Qty: | 20.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|--|-------|----------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | | Date: | 09-10-14 | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3953 | A | | | | | | | | |

100

0.00



Doosan

Doosan Lathe

Memo

Turn as per folio FA853 & DWG
FOLIO REV: AS
DWG REV: A

0.00

09.10.21

20

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

09.10.21

20

Work Order ID 52809

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Page 2

Item ID: D3953-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Stud, Base

Start Date: 14/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

SA 09/10/21

20



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 139C

0.00



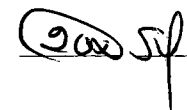
Packaging

Memo

0.00

Packaging

9/10/23



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

A 09.10.27

ME 09-10-23

Picklist Print

Page 1

October 14, 2009 11:48:34 AM

Work Order ID: 52809



Parent Item: D3953-5



Parent Item Name: Gas Spring Stud, Base

Start Date: 14/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304R1.750 | | Purchased | No | | | 100 | f | 0.0000 | 2.6316 | | | |
| | | | | | | | | | | | | |

304 ROUND BAR 1.750

09.10.21 *M11239*
M112939

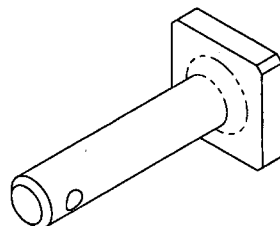
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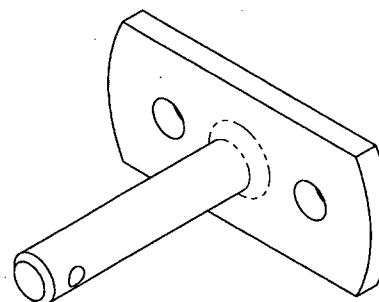
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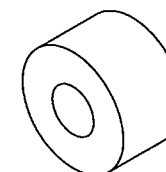
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



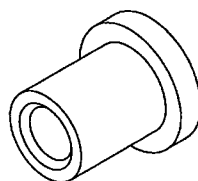
D3953-5 GAS SPRING STUD, BASE



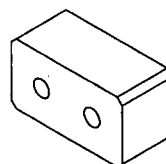
D3953-7 GAS SPRING SPACER



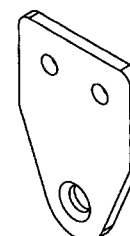
D3953-9 GAS SPRING WASHER



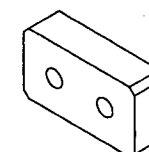
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)

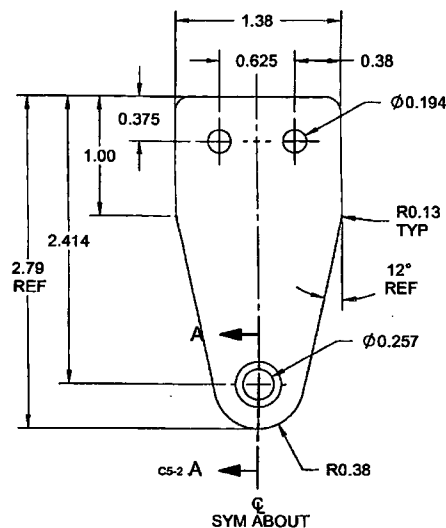
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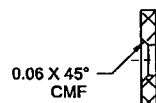
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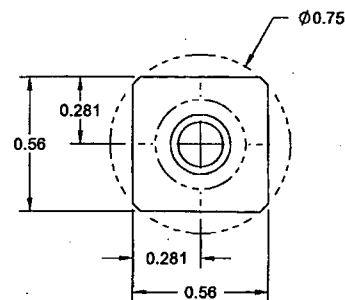
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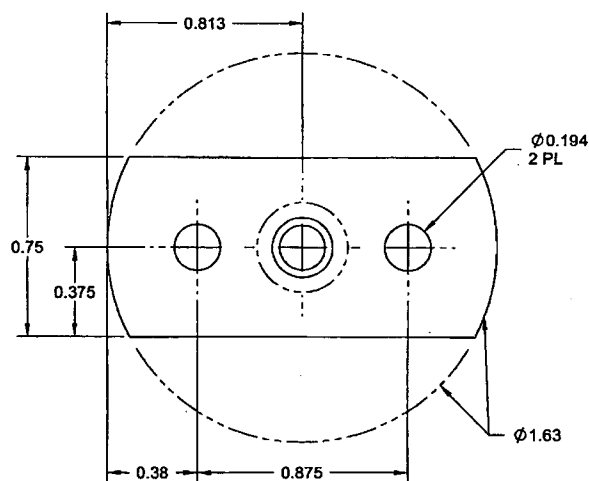
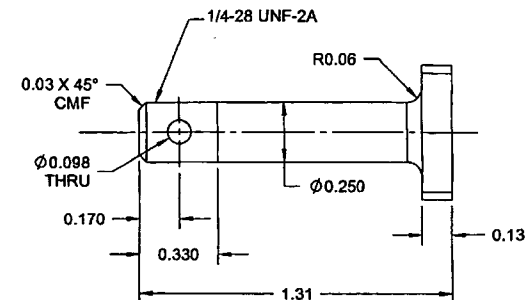
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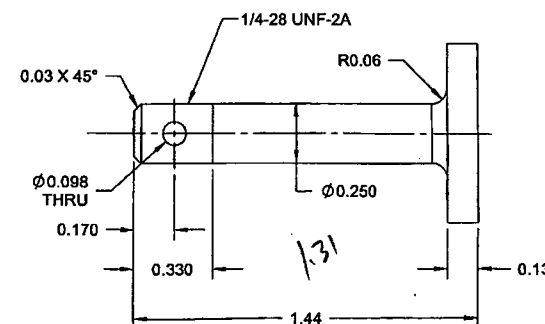
SECTION A-A C7.2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.11 lbs

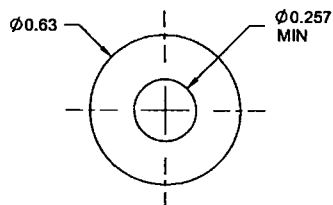
-3: 0.03 lbs

-5: 0.06 lbs

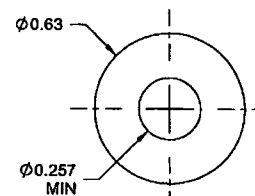
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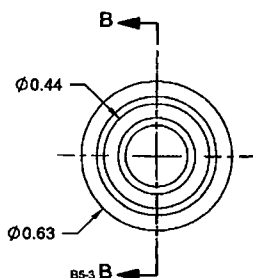
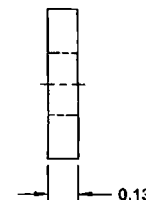
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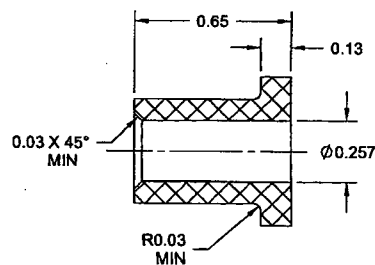
D3953-7 GAS SPRING SPACER



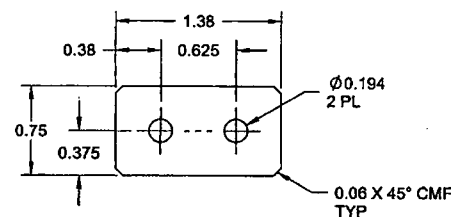
D3953-9 GAS SPRING WASHER



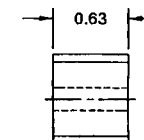
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



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2009-10-08
JAP

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

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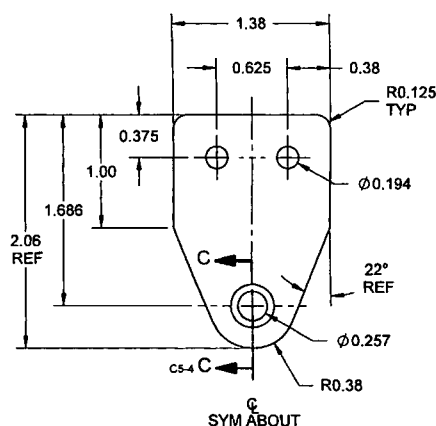
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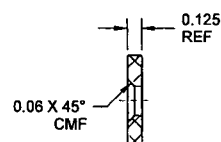
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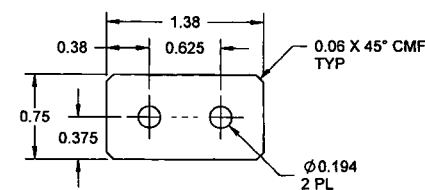
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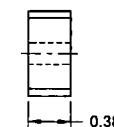
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)



NOTES:

1) MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

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2009-10-08

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| | | |
|---|-------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 52809 |
| Description: GAS SPRING STUD, BASE | | Part Number: D3953-5 |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| .813 | +/- .010 | .813 | / | | | |
| .75 | +/- .030 | .75 | / | | | |
| .375 | +/- .010 | .375 | / | | | |
| .194 Ø | + .005 - .001 | .196 | / | | | |
| .38 | +/- .030 | .380 | / | | | |
| .875 | +/- .010 | .875 | / | | | |
| 1.63 | +/- .030 | 1.633 | / | | | |
| 1/4-28 UNF | 2A | .265 M.O.W. | / | | | |
| .03 x 45° | +/- .030 | .020 | / | | | |
| R.06 | +/- .030 | R.06 | / | | | |
| .098 Ø | + .004 - .001 | .100 | / | | | |
| .170 | +/- .010 | .170 | / | | | |
| .330 | +/- .010 | .330 | / | | | |
| .250 Ø | +/- .010 | .245 | / | | | |
| 1.44 | +/- .030 | 1.442 | / | | | |
| .13 | +/- .030 | .132 | / | | | |
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|--|---------------------------------------|--------------------------------|
| Measured by: <i>[Signature]</i> | Audited by: <i>[Signature]</i> | Prototype Approval: N/A |
| Date: 09.10.21 | Date: 09/10/21 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |